

Date: Thursday, 11/29/2007 11:06:55 AM
 User: Kim Johnston

Process Sheet

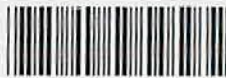
Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 36040 - 2
 Estimate Number : 12712
 P.O. Number : N/A
 This Issue : 11/29/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL / MED FAB
 Previous Run : 35696
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A New Issue 07-02-14 JLM

Drawing Name : WEARPAD
 Part Number : D35371
 Drawing Number : D3537 REV C
 Project Number : N/A
 Drawing Revision : C
 Material : N/A
 Due Date : 12/10/2007

Qty: 100 Um: Eac

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M304S16GA 304/316 .063 Sheet



8.5104



Comment: Qty.: 0.0788 sf(s)/Unit Total: 7.8750 sf(s)

M304S16GA .063" 304 SS SHEET

Batch: 105947 IB 07-12-6

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3537

Dwg Rev: C

Prog Rev: C

IB 07-12-6

108

2-Deburr if necessary

IB 07-12-6

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 07-12-6



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

7/12/06 108

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D3537-1

7/12/11

1. $\frac{1}{x^2} = x^{-2}$
 $\frac{d}{dx} x^{-2} = -2x^{-3} = -\frac{2}{x^3}$
 $\frac{d}{dx} \frac{1}{x^2} = -\frac{2}{x^3}$

2. $\frac{d}{dx} \ln(x) = \frac{1}{x}$
 $\frac{d}{dx} \ln(x^2) = \frac{1}{x^2} \cdot 2x = \frac{2}{x}$
 $\frac{d}{dx} \ln(x^3) = \frac{1}{x^3} \cdot 3x^2 = \frac{3}{x}$
 $\frac{d}{dx} \ln(x^4) = \frac{1}{x^4} \cdot 4x^3 = \frac{4}{x}$
 $\frac{d}{dx} \ln(x^5) = \frac{1}{x^5} \cdot 5x^4 = \frac{5}{x}$
 $\frac{d}{dx} \ln(x^6) = \frac{1}{x^6} \cdot 6x^5 = \frac{6}{x}$
 $\frac{d}{dx} \ln(x^7) = \frac{1}{x^7} \cdot 7x^6 = \frac{7}{x}$
 $\frac{d}{dx} \ln(x^8) = \frac{1}{x^8} \cdot 8x^7 = \frac{8}{x}$
 $\frac{d}{dx} \ln(x^9) = \frac{1}{x^9} \cdot 9x^8 = \frac{9}{x}$
 $\frac{d}{dx} \ln(x^{10}) = \frac{1}{x^{10}} \cdot 10x^9 = \frac{10}{x}$

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/01/12	#9.0	W/O was split for 38 pcs	↓	08/01/12	x38		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/05	#2.0	6 parts have a dim. of 3.600 instead of 3.625 FL water jet cut too small.	PT 07.12.05 per QSF042	Parts are acceptable this on time only. Acceptable edge distance remains based on E/D=1.5	IB 07-12-05	↓ 07/12/05	PT 07-12-05 per QSF042	↓ 07/12/05

NOTE: Date & initial all entries

1. The first part of the paper is devoted to a general discussion of the problem of the existence of solutions of the system of equations (1) and (2) under the assumption that the functions $f_i(x)$ and $g_j(x)$ are continuous and satisfy certain conditions. It is shown that under these conditions the system has a unique solution in the class of continuous functions.

2. In the second part of the paper, the problem of the existence of solutions of the system of equations (1) and (2) is considered under the assumption that the functions $f_i(x)$ and $g_j(x)$ are continuous and satisfy certain conditions. It is shown that under these conditions the system has a unique solution in the class of continuous functions.

3. In the third part of the paper, the problem of the existence of solutions of the system of equations (1) and (2) is considered under the assumption that the functions $f_i(x)$ and $g_j(x)$ are continuous and satisfy certain conditions. It is shown that under these conditions the system has a unique solution in the class of continuous functions.

4. In the fourth part of the paper, the problem of the existence of solutions of the system of equations (1) and (2) is considered under the assumption that the functions $f_i(x)$ and $g_j(x)$ are continuous and satisfy certain conditions. It is shown that under these conditions the system has a unique solution in the class of continuous functions.

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 36040

Part Number: D35371

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty

Description

Batch

A/R

2059B Hardcoat

M106390 / M105959

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

8/08/01/02 (38)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10/09/01/02 (38)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11/08/01/02 (38)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M105642

FX 08/01/02 (38)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-01-02 (38)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-20

MS

08-01-02 (38)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



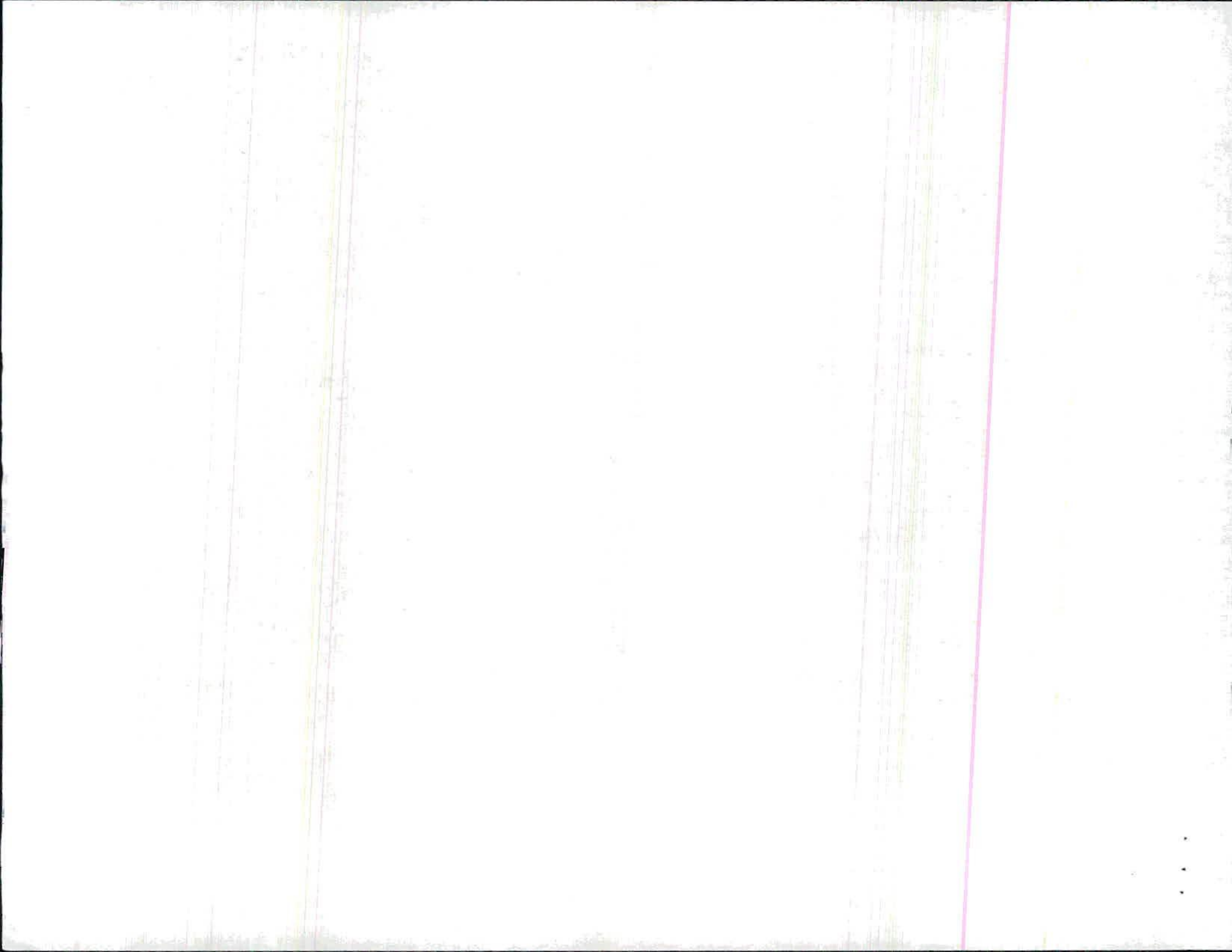
Comment: FINAL INSPECTION/W/O RELEASE

12/08/01/03

Job Completion



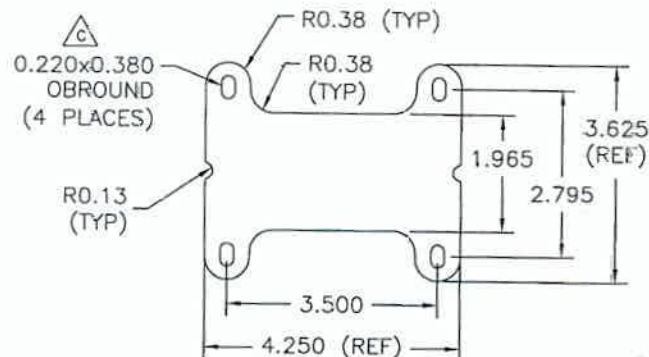
2008/1/2
W



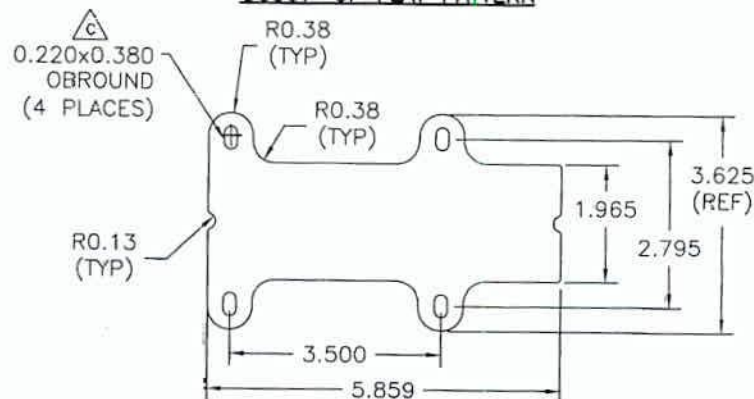
Handwritten text on the left side of the page, appearing to be a list or series of entries, possibly related to a survey or inventory. The text is faint and difficult to read.

Handwritten text on the right side of the page, continuing the list or series of entries. The text is faint and difficult to read.

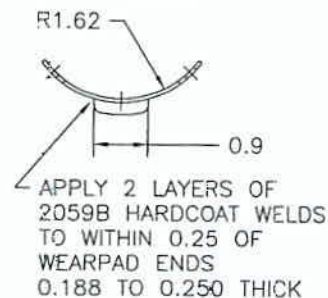
D3537-1F FLAT PATTERN



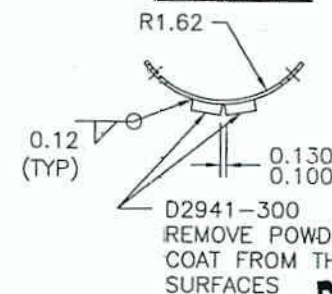
D3537-3F FLAT PATTERN



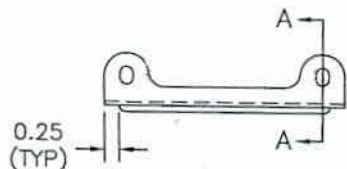
SECTION A-A



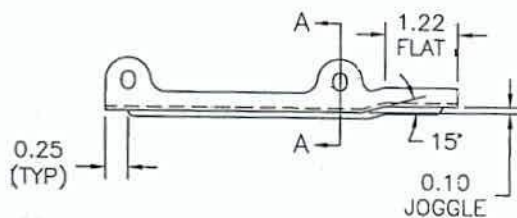
SECTION B-B



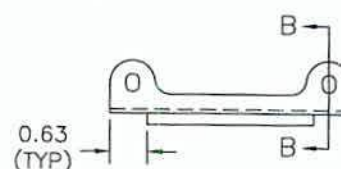
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



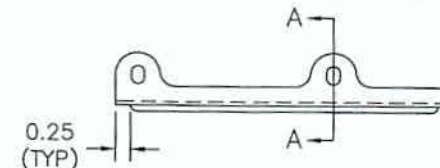
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	4	APPROVED 4
DATE	07.04.13	TITLE WEARPAD
		DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
		DRAWING NO. D3537
		REV. C
		SHEET 1 OF 1
		SCALE 1:2

RELEASED
07.05.08 PH
PER ELM

50